

81755

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/19/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/6/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Date: 12-03-11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

Revision Nbr

D4030

C

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00

110

HandFinish

Memo

0.00

Hand Finishing

***Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ***

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

12/4/1998
ms
12-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-210 200 Placard, Max Load per NCR 12-1239		Manufactured	No				Each	5.0000		1			682827 \$
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		4							
				66275		1							
				76298		3							
				ST124		1							
				64869		1							
D2530 Handle Weldment		Manufactured	No			100	Each	8.0000	1				392150 sl
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		8							
				77030		2							
				78965		6							
D2535 Spring		Manufactured	No			100	Each	42.0000	2		2		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		42							
				77488		42			2				
D2537 Bushing		Manufactured	No			100	Each	32.0000	2		2		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		32							
				77055		32			2				
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1		1		3/12/04/17
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1		1		3/12/04/17

B82891 (K)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 81755

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3917-3	Manufactured	No	100	Each	115.0000	6	6	
Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST070	115				
			76956	4				
			80598	9				
			81205	102				
D3953-3	Manufactured	No	100	Each	24.0000	2	2	
Gas Spring Stud, Lid								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	24				
			76659	4				
			78042	20				
D3953-7	Manufactured	No	100	Each	12.0000	2	2	
Spring Spacer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	12				
			76295	12				
D3953-9	Manufactured	No	100	Each	16.0000	2	2	
Gas Spring Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	16				
			78916	16				
D3953-17	Manufactured	No	100	Each	5.0000	2	2	
Gas Spring Spacer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	5				
			76294	5				
D3953-19	Manufactured	No	100	Each	13.0000	1	1	
Gas Spring Bracket								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST075	13				
			75227	13				

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Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 81755

Parent Item: D4030-041

Start Date: 3/19/2012

Required Date: 4/6/2012

Parent Item Name: Long Basket Assembly (350)

Start Qty: 1.00

Required Qty: 1.00

D3953-21	Manufactured	No	100	Each	0.0000	1	1
Gas Spring Bracket							
D3969-3	Manufactured	No	100	Each	14.0000	1	1
Spring (Basket Lid)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	14	
64285	1	
73515	13	

AN3-14A	Purchased	No	100	Each	92.0000	4	4
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	92	
119328	92	

AN3-16A	Purchased	No	100	Each	135.0000	2	2
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	135	
117441	49	
118628	36	
120986	50	

AN5-17A	Purchased	No	100	Each	80.0000	4	4
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338	80	
117872	42	
120498	38	

AN4-12	Purchased	No	100	Each	86.0000	3	3
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	86	
118626	11	
119775	25	
120986	50	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 81755

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

AN310-4
NUT

Purchased

No

100 Each 72.0000

3

Location

Loc Qty

Loc Code

ST344

72

120124

22

120518

25

121011

25

AN310C4

Purchased

No

100 Each 46.0000

2

Nut

Location

Loc Qty

Loc Code

ST344

46

119324

16

120360

30

MS21042L3

Purchased

No

100 Each 3,041.0000

6

Nut

Location

Loc Qty

Loc Code

ST300

3041

117441

16

117885

32

118451

5

118927

3

119017

2812

119075

173

MS21042L5

Purchased

No

100 Each 1,598.0000

4

Nut

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81755

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Purchased No

100 Each 311.0000 3 3

Cotter Pin

Location Loc Qty Loc Code

ST309 311

17566 311

MS24665-300 Purchased No

100 Each 208.0000 2 2

Cotter Pin

Location Loc Qty Loc Code

GA 200

118234 200

ST309 8

116823 8

NAS1149F0432P Purchased No

100 Each 322.0000 6 6

Washer

Location Loc Qty Loc Code

ST275 322

120360 122

121060 200

NAS1149F0563P Purchased No

100 Each 89.0000 4 4

Washer

Location Loc Qty Loc Code

ST275 89

117735 89

NAS1149F0332P Purchased No

100 Each 654.0000 8 8

WASHER

Location Loc Qty Loc Code

ST275 654

117735 37

119225 14

120498 200

120910 200

120986 200

17317 3

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, March 16, 2012 3:38:18 PM

Page 6

Work Order ID: 81755

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

2,526.0000

2

2

Washer

12/1/13

Location

Loc Qty

Loc Code

ST297

2526

117291

1526

119124

1000

2x

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

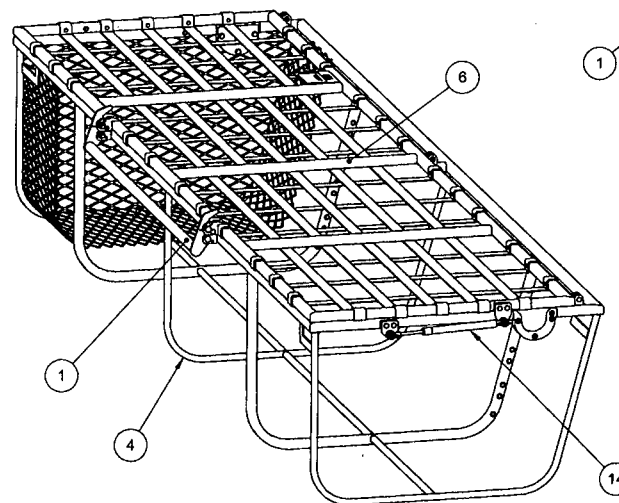
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

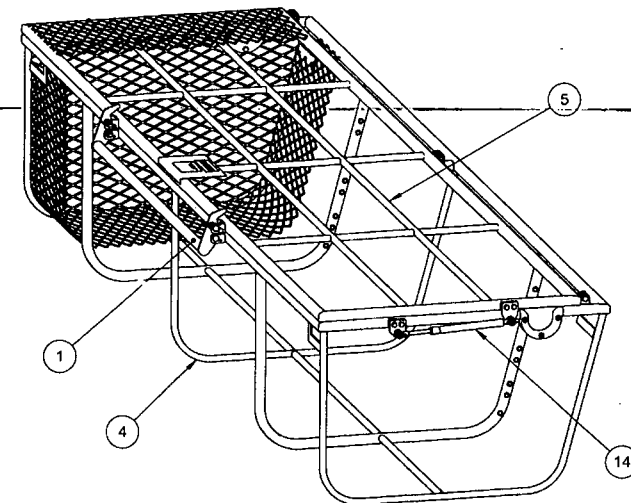
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: -041: 72 lbs APPROX
 -043: 57 lbs APPROX

RELEASED
 10.08.12.07
 ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	OP		
CHECKED	JFS		
MFG. APPR.	JFS		
APPROVED	JFS		
DE APPR.	JFS		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D4030	REV. C
		TITLE LONG BASKET ASSY (350)	SHEET 1 OF 3
		SCALE NTS	
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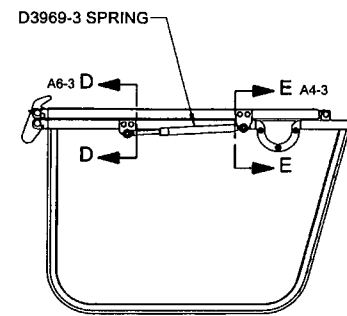
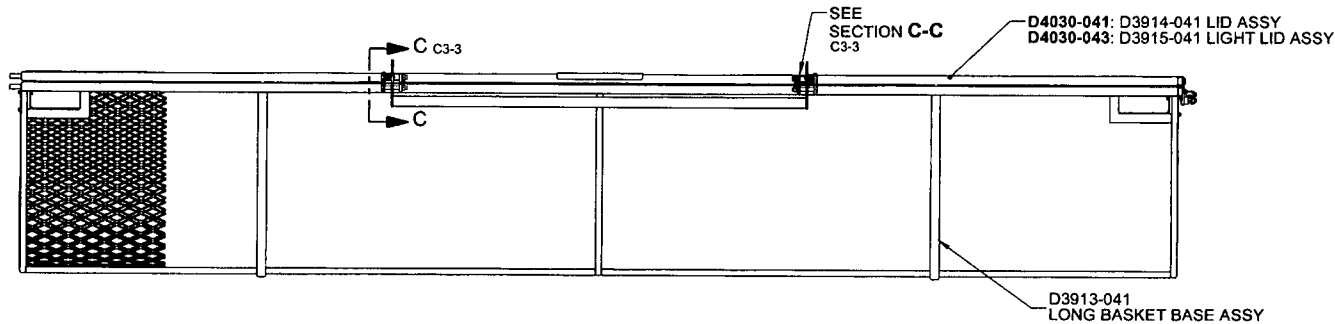
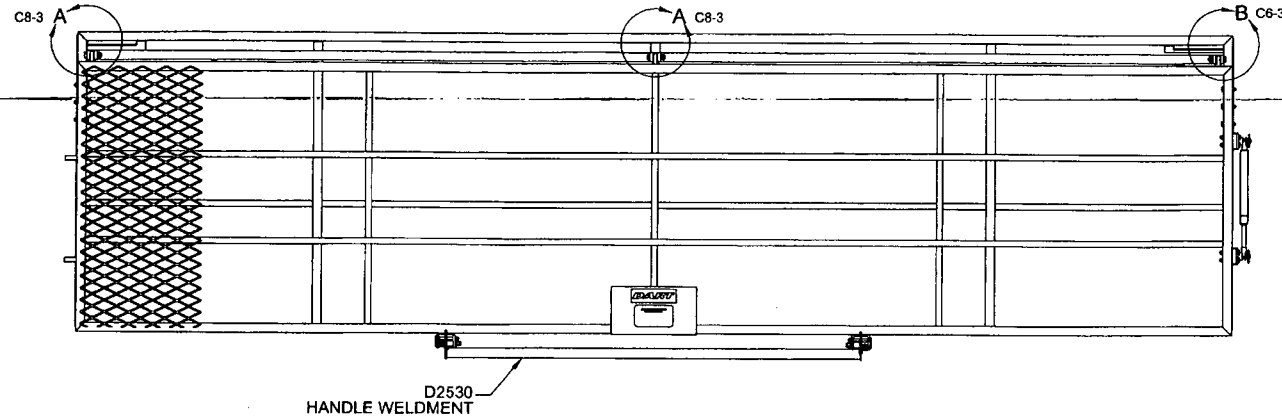
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY. LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D4030	SHEET 2 OF 3
MFG. APPR.	JES/BS/L	TITLE	SCALE
APPROVED	MP	LONG BASKET ASSY (350)	NTS
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.23		

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

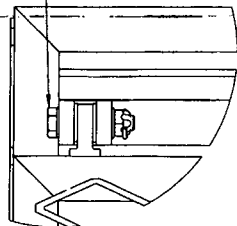
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

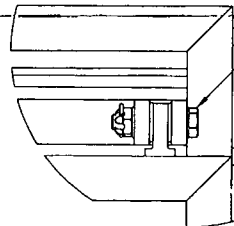
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



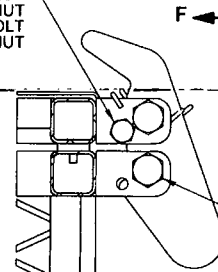
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

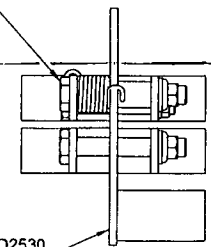


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

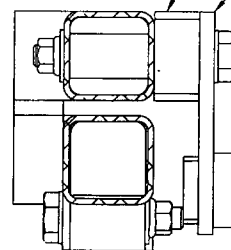
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D4030	SHEET 3 OF 3
MFG. APPR.	JFS	TITLE	SCALE
APPROVED		LONG BASKET-ASSY (350)	NTS
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DATE	10.07.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries